

Amos

Work Order ID 149196

149196

Page 1

July 21, 2016 3:20:06 PM

Item ID: D3389-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web

Start Date: 8/31/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/9/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: SH Date: 7/25/16

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3389	Rev D
-------	-------

100

0.00

100

Skidtubes

Skidtubes

Memo

0.33

- 1- Pick D2500-3-100
- 2- Deburr
- 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.
- 4- Cut to finished length
- 5- Open holes to finished size as per dwg D3389
- 6- Deburr

10 ϕ 16-10-13

Handwritten signature

DAS
18
9-89

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

10 ϕ 16-10-17

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☒ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge
☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier
				☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing
				☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due
				OTHER : _____			

Work Order ID 149196

July 21, 2016 3:20:06 PM

149196

Page 2

Item ID: D3389-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 8/31/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/9/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120						(X10)	✓		2016/10/17
HandFinish	Memo	0.35							BEB
Hand Finishing									
130	QC7-Inspect Chemical Conversion Coat	0.00							
130						10	✓	16-10-18	DAS 19 9-89
QC	Memo	0.02							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG002</u>	0.00							
140						10	✓	16-10-18	
Packaging	Memo	0.02							
Packaging	LOCATION: <u>LG002</u>								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :						

Work Order ID 149196

July 21, 2016 3:20:06 PM

149196

Page 3

Item ID: D3389-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Web

Start Date: 8/31/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/9/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.17

OCT 1 R 2016
OCT 1 R 2016DAS
21
9-89DAS
21
9-89

OCT 1 R 2016

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

July 21, 2016 3:20:06 PM

Page 1

Work Order ID: 149196

149196

Parent Item: D3389-1

D3389-1

Parent Item Name: Web

Start Date: 8/31/2016

Required Date: 9/9/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A05.08.31New issueKJ/JLM
IPP Rev:B 06-02-08 As per Rev C JLM
IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	10.0000	1	10			

D2500-3-100

Ext'n -I' Beam Web 4"

16-10-13 D.J.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	10	
133211	10	

133211

1047804

10

DQA: _____ Date: _____

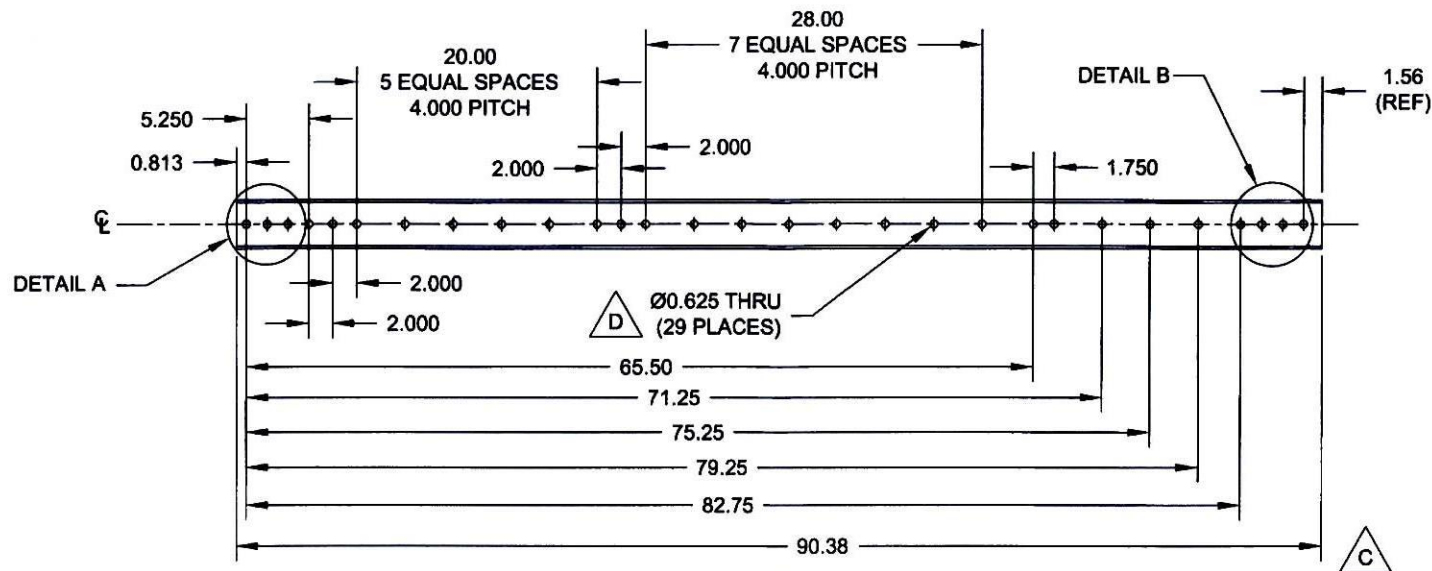


WORK ORDER NON-CONFORMANCE / UPDATE

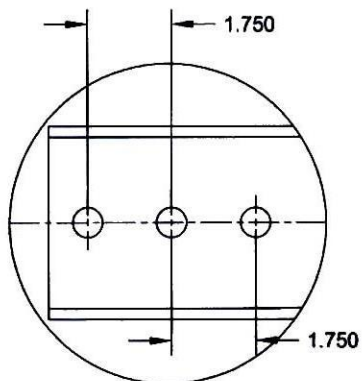
QA Closed: _____ Date: _____

Work Order update only ☐

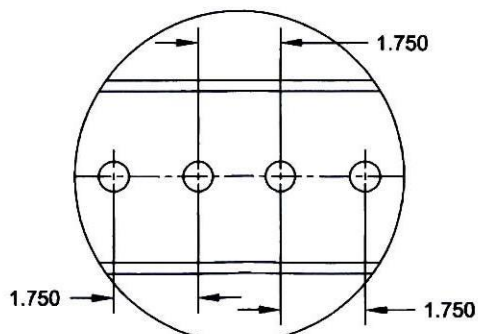
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OTHER : _____					



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

7/25/16 SH
149196

D	REVISE HOLE DIAMETER FROM $\varnothing 0.257$ TO $\varnothing 0.625$, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWING NO. D3389	REV. D
TITLE 412 WEB	SHEET 1 OF 1
	SCALE 1:10

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